

Work Order ID 61638

Monday, August 30, 2010 3:47:41 PM



Page 1

Item ID: D2596

Accept



Setup Start



Revision ID:

Stop



Item Name: Web, 205 Skidtube

Start Date: 8/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

X6

BB 10/09/01

110

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

X6

BB 10/09/02

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

X6

BB 10/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2596 PAR #: _____ Fault Category: Skid tubes NCR: (Yes) No DQA: [Signature] Date: 10-09-13
 Resolution: Accepted Disposition: use as is QA: N/C Closed: [Signature] Date: 10/09/13

NCR: <u>61638</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.09.07</u>	<u>100</u>	<u>ONE HOLE OPENED TO 4 0.750 by error instead of 0.625" R.C. L.O.A. = 0.500 incorrect tool.</u>	<u>CP</u> <u>10.09.07</u> <u>OS/042</u>	<u>Acceptable</u>	<u>BB</u> <u>10/09/08</u>	<u>DP</u> <u>10-9-08</u>	<u>P</u> <u>10.09.07</u> <u>OS/042</u>	<u>/</u> <u>1009-13</u>

NOTE: Date & initial all entries

Work Order ID 61638

Monday, August 30, 2010 3:47:41 PM



Page 2

Item ID: D2596

Accept



Setup Start



Revision ID:

Stop



Item Name: Web, 205 Skidtube

Start Date: 8/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

(X6)

BB

10/09/08

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/08

MF

10-9-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 3:47:45 PM

Page 1

Work Order ID: 61638



Parent Item: D2596

Parent Item Name: Web, 205 Skidtube


Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D□99.02.02□Changed QA to QC, Added Step 6 and Cost□DM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 		Manufactured	No			100	Each	95.0000	1	6			

Ext'n - 'I' Beam Web 4"

Location

LG

Loc Qty

95

Loc Code

51957

95

X6

10/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

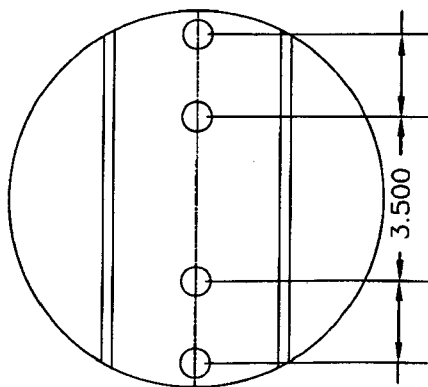
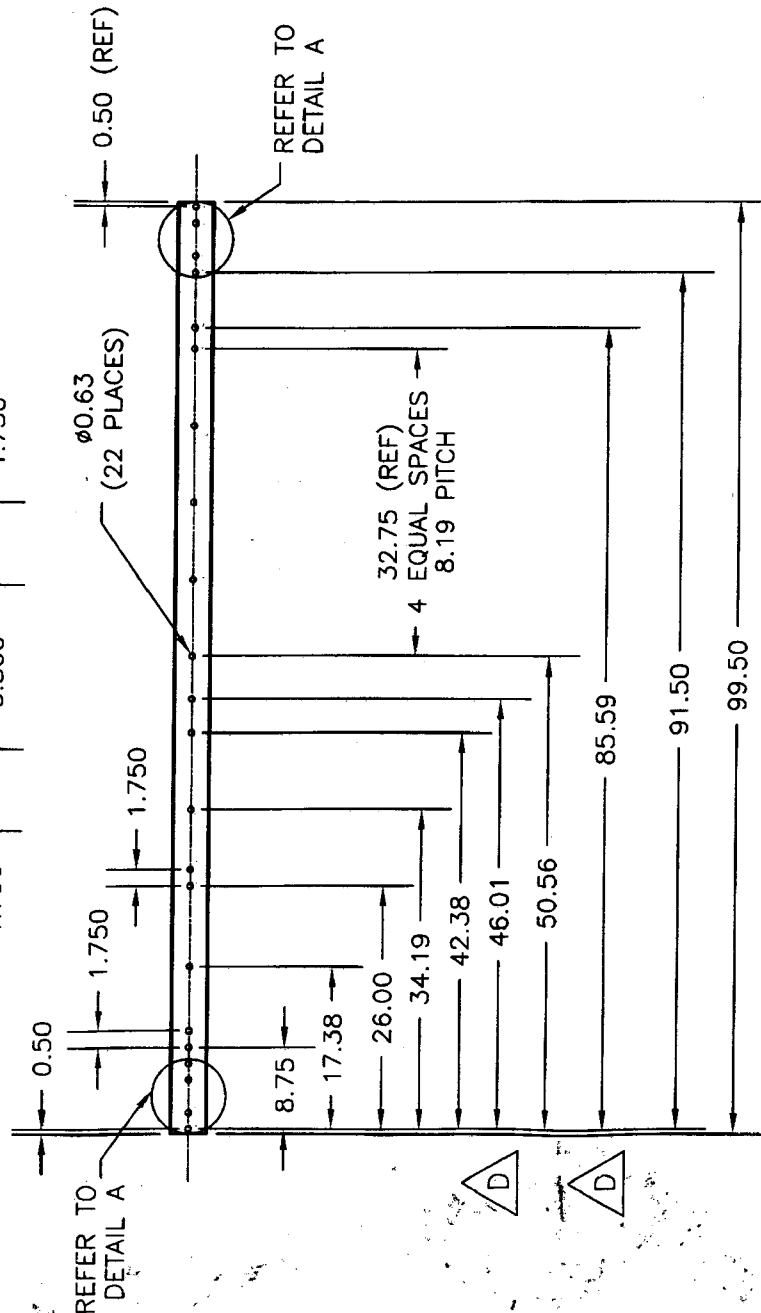
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.18SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ONLYNO. *4438**2/10-8-90***DETAIL A**
SCALE 1:4**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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